



007908

Dart Aerospace Ltd.
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RBE117-12010W73
Job Sheet 185534



Part No: RBE117-12010W73

Job Qty: 1 pcs

Part Name: Retainer Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/18

Job Tracking No:

Due Date: 12/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-12010W73 Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/27/18		0.00	1.00	Small Fab - 1		DAS 58 9-89 FEB 07 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/27/18		0.00	0.00	QC 5 - 10		DAS 28 9-89 1/10/07
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/27/18		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	12/27/18	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
						9-25
Part Op 110 - Small Fab - 1-Assemble as per DWG. Descriptions: 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
92625A516	Wing Head Screw	4 Ea (4 ea)	110-Small Fab - 1			
98381A667	Dowel Pin	2 Ea (2 ea)	110-Small Fab - 1			
RBE117-12010W73-1-PO	Cap	1 pcs (1 ea)	110-Small Fab - 1			
RBE117-12010W73-3	Base	1 Ea (1 ea)	110-Small Fab - 1			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Small Fab - 1	92625A516	4	6	0		
	98381A667	2	10	0		
	RBE117-12010W73-1	1	3	0		
	RBE117-12010W73-3	1	6	0		
Part Specifications						
Specifications could not be found.						



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RBE117-12010W73

Job Sheet 185534



10089
pcc 21

Part No: RBE117-12010W73

Job Qty: 1 ea

Part Name: Retainer Plate



Part Weight: 0 lbs

Status: New

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Job Created: 10/29/18

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Type: SOLD

Description:

Note: DWG RBE117-12010W73 Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/27/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		12/27/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		12/27/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/27/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/27/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92625A516	Wing Head Screw	4 (4 ea)	90-Start up Operation	5124955
98381A667	Dowel Pin	2 (2 ea)	90-Start up Operation	5142206
RBE117-12010W73-1 - po	Cap	1 Ea (1 ea)	110-Small Fab	5136279
RBE117-12010W73-3 outsource	Base	1 Ea (1 ea)	110-Small Fab	5137461

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	92625A516	4	0	0
	98381A667	2	0	0
110-Small Fab	RBE117-12010W73-1	1	0	0
	RBE117-12010W73-3	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

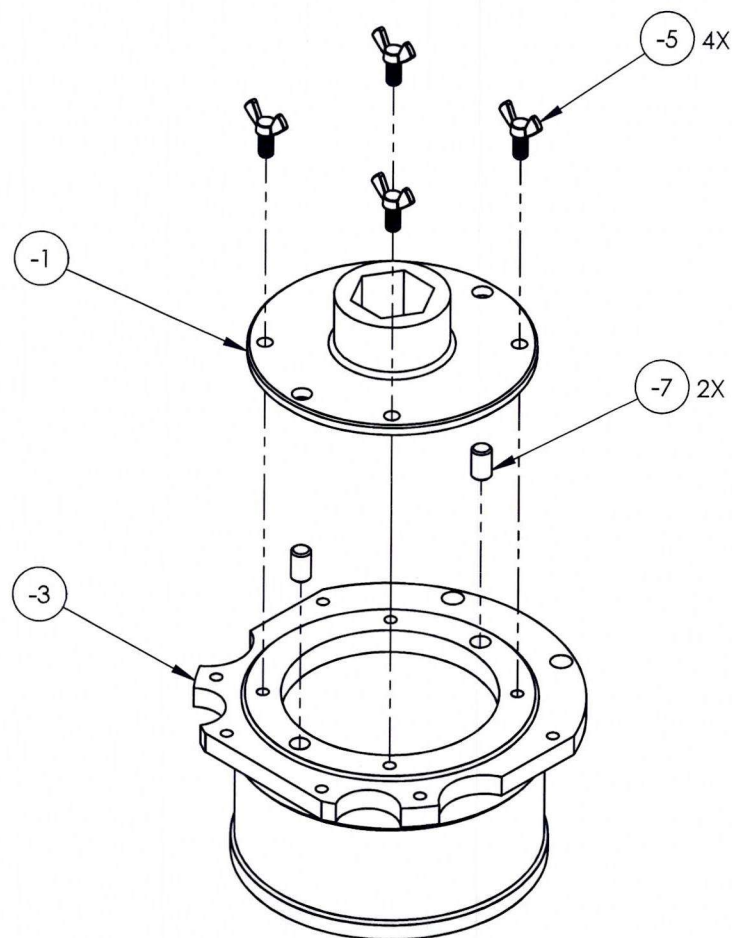
QA Closed: _____ Date: _____

Work Order update only ☐

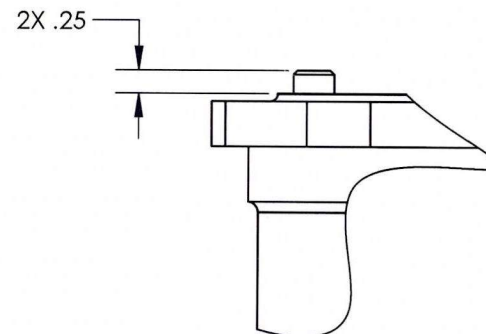
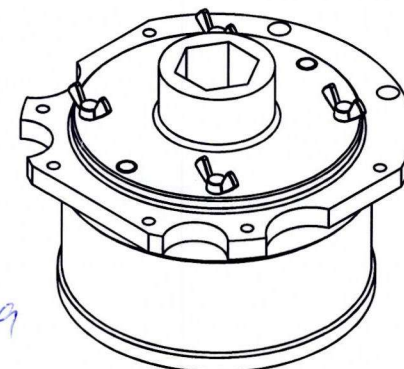
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION		5/17/2016	SM	JAG



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185534 MW
187029



NOTES:

1. REF. EUROCOPTER T/N 117-12010W73.
2. PART OF KIT RBE117-12010W62.

DART AEROSPACE	
TITLE RETAINER PLATE	
DWG NO. RBE117-12010W73	REV 1
MAT'L _____ HEAT TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL EC 145	
DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	SCALE 1:4 DATE 2/23/2016 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	CAP	4140/4142		2
			-3	1	BASE	4140/4142		3
		B/O	-5	4	WING HEAD SCREW	S.S.	M8X1.25X16MM (MCMASTER-CARR # 92625A516)	1
		B/O	-7	2	DOWEL PIN	STEEL	Ø7/16 X 3/4 (MCMASTER-CARR # 98381A667)	1



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Container No: S151655



Part: RBE117-12010W73

Job No: 185534

Serial No/Batch: S151655

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 32/07/19